

Work Order ID 137932

Thursday, October 15, 2015 12:59:58 PM

137932

Page 1

Item ID: D412-709-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Escape Panel Modification Clear Fits LH or RH

Stop

NS2

Start Date: 10/15/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/15/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MUS

Date: OCT 15 2015

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-709	Rev C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-709-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MUS

OCT 19 2015

4

4

OCT 19 2015

DAS

27

9-89

4X

DAS

OCT 19 2014

28

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 137932

Thursday, October 15, 2015 12:59:58 PM

137932

Page 2

Item ID: D412-709-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 10/15/2015 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 10/15/2015 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00		DAS 6 9-89					
130	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-011 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140	Memo	0.01							
QC									
Quality Control									

OCT 19 2015

DAS
29

OCT 19 2015

MCS

MCS OCT 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

Thursday, October 15, 2015 1:00:02 PM

Page 1

Work Order ID: 137932

137932

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 10/15/2015

Required Date: 10/15/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC IPP Rev:D
10.05.20 added D3561-1 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN6-20A		Purchased	No			110	Each	49.0000	3	12			
AN6-20A									**	130466 3		DAS 27 9-89	
BOLT													

DAS
28
9-89

Location

Loc Qty

Loc Code

ST286A

25

M128936

25

ST334

24

M132576

24

D3118-3

Manufactured No

D3118-3

Sign Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST017

5

131395

5

D3224-1

Manufactured No

D3224-1

Frame

DAS
28
9-89

Location

Loc Qty

Loc Code

ST441

5

130482

5

OCT 19 2015

DAS
27
9-89

Picklist Print

Thursday, October 15, 2015 1:00:02 PM

Page 2

Work Order ID: 137932

137932

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 10/15/2015

Required Date: 10/15/2015

Start Qty: 4.00

Required Qty: 4.00

D3239-1

Manufactured No

110 Each

17.0000

2 8

D3239-1

Cover

OCT 19 2015

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST031

17

131565

5

133103

12

110

Each

0.0000

1 4

D412-709-013

Manufactured No

D412-709-013

Escape Panel Push-Out Window Clear Fits LH or RH

MS21042L3

Purchased

No

110

Each

734.0000

2 8

MS21042L3

Nut

OCT 19 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

334

M130922

334

GA

144

M131317

144

ST305

256

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M133134

157

DAS
28
9-89

8

Thursday, October 15, 2015 1:00:02 PM

Shop Packet Print

Page 2

Picklist Print

Thursday, October 15, 2015 1:00:02 PM

Page 3

Work Order ID: 137932

137932

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 10/15/2015

Required Date: 10/15/2015

Start Qty: 4.00

Required Qty: 4.00

MS21042L6

Purchased

No

110

Each

365.0000

3

12

DAS

6

9-89

DAS

27

9-89

MS21042L6

Nut

Location

Loc Qty

Loc Code

CCK007

100

m133031

100

ST273A

143

m131624

143

ST305

105

m129909

1

m132262

4

m133134

100

t260a

17

m131317

17

DAS

6

9-89

DAS

27

9-89

MS35207-262

Purchased

No

110

Each

122.0000

2

8

MS35207-262

Screw

Location

Loc Qty

Loc Code

ST276

122

M131420

22

M132823

100

NAS1149D0332J

Purchased

No

110

Each

1,656.000

2

8

NAS1149D0332J

Washer

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

415

m132677

415

ST269

1227

m130325

877

m132677

350

DAS

6

9-89

DAS

27

9-89

DAS

28

9-89

OCT 19 2015

Thursday, October 15, 2015 1:00:02 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, October 15, 2015 1:00:02 PM

Page 4

Work Order ID: 137932

137932

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 10/15/2015

Required Date: 10/15/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0616J

Purchased

No

110

Each

248.0000

5

20

DAS

6

DAS

27

9-89

NAS1149D0616.J

WASHER

DAS

28

Location

Loc Qty

Loc Code

ST269

248

122815

248

20

NAS1149D0663J

Purchased

No

110

Each

1,168.000

5

20

NAS1149D0663.J

Washer

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST260a

874

M132256

574

M133134

300

ST269

67

M126334

67

DAS

28

DAS

27

DAS 9-89

6

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Work Order ID 137932

Thursday, October 15, 2015 12:59:58 PM

137932

Page 1

Item ID: D412-709-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 10/15/2015 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 10/15/2015 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MCS Date: OCT 15 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-709-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS OCT 19 2015

(4)

DAS
28
840

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041	WINDOW ASSEMBLY
	1						D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C

Date: 06.11.27